



PRODUCT

DATA SHEET

Stainless Steel Electrode

Weld Process: Shielded Manual Metal Arc

Alloy: 2209 Class: E2209-16

Conforms to Certification: AWS A5.4 / ASME SFA 5.4

Alloy: DM2209-16

AWS Chemical Composition Requirements

C = 0.04 max Si = 1.0 max
Cr = 21.5 – 23.5 P = 0.04 max
Ni = 8.5 – 10.5 S = 0.03 max
Mo = 2.5 – 3.5 Cu = 0.75 max
Mn = 0.5 – 2.0 N = 0.08 – 0.20

Deposited All Weld Metal Properties % (Typical) As-Welded

Yield Strength 115,000psi
Tensile Strength 90,000psi
Elongation 27%

Deposited Chemical Composition % (Typical)

C = 0.03 Si = 0.45
Cr = 23.00 Mn = 0.95
Ni = 9.70 Mo = 3.00

Deposited Charpy-V-Notch Impact Properties %

Not Applicable

Recommended Welding Parameters

<u>Diameter</u>	<u>Voltage</u>	<u>Amperage Flat Position</u>	<u>Amperage Vertical & Overhead</u>
3/32	24-28	70-85	65-75
1/8	26-30	85-110	80-90
5/32	28-32	110-140	100-120
3/16	28-32	120-160	110-130



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Application

E2209-16 is used to weld duplex stainless steels. Welds offer excellent resistance to stress corrosion and cracking.